


ITEM #	QTY	PART #	TITLE	PG
-1	1	RBT400213-1	TAB BENDER BODY	2
-7	1	RBT400213-7	TOP TAB ASSY	3
-9	1	RBT400213-9	POINTER	7
15	4	NAS1149F0432P	WASHER 1/4"	-
17	4	AN350-4	WING NUTS 1/4"-28	-
19	2	AN470AD-4-7	HEAD RIVET 1/8" x 7/16"	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
A	CH'D TITLEBLOCK & REVISION BLOCK, CH'D DWG. NO. FROM 407-215-001-101, CH'D DESCRIPTION IN BOM P/N -1, -3, -4, -5.	-	6/18/2009	RJC	-
1	ADDED -9 & -19, CH'D DESIGN -1 PER S.E. SEPARATED PARTS TO INDIVIDUAL SHEETS, CREATED ASSY. DWG. & -7 ASSY. DWG.	-	4/27/2011	RJC	-
2	CH'D -1 CHAMFER FROM 1/16 & CH'D FINISH FROM POWDER COAT YELLOW ADDED -5 FINISH PER R.W. MOVED #30 HOLE TO BE SYMENTRICAL WITH RIGHT SIDE PER S.E. DELETED -7 FINISH & NOTE 2 PER R.W.	-	8/25/2011	RJC	RW
3	-1 CH'D TWO HOLES DIM'S, WAS R.064 (x2) IS Ø.125 (X2).	-	12/26/2013	RJC	GE
4	UPDATED TO NEW DRAFTING STANDARDS. -1 CH'D DIM WAS .250 IS (250). -3, -4 CH'D DIMS WAS DRILL #30 THRU X2 IS 2X Ø.129 THRU, WAS .500 IS (.500). -5 CH'D DIM WAS DRILL #30 THRU CSK 100° X .24 OD 4 PLACES IS 4X Ø.129 THRU Ø.24 X 100°. -7 CH'D DIM WAS 11.580 IS (11.580). -9 CH'D DIMS WAS 1.051 IS (1.051), WAS .801 IS (.842), WAS .301 IS .347. ADDED DIMS (.311), (.381), .500. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	15-0021	1/26/2015	DPD	JAG
F	TEMPLATE UPDATED, NOTE 7 ADDED, ITEM 15 AN960-416L WASHER CHANGED FOR NAS1149F0432P	17-797	17.12.21	VM	ML

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) SPEC: N/A
5) BREAK ALL SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) HAND TIGHTEN ONLY

RBT400213 407 TRIM TAB BENDER



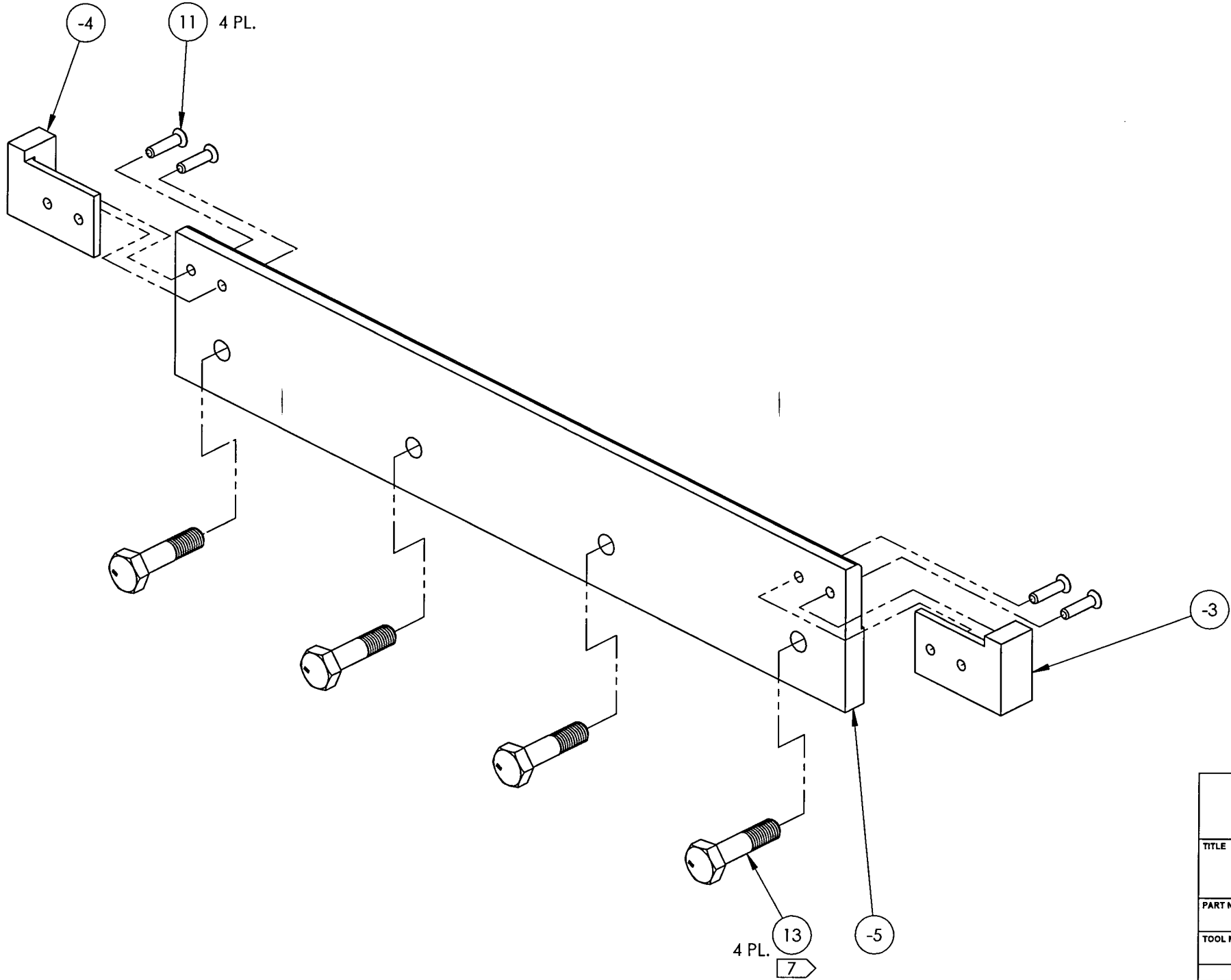
DART
AEROSPACE
Hawkesbury, Ontario, Canada

TITLE			
407 TRIM TAB BENDER			
PART NO.			REV
RBT400213			F
TOOL NO.		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
RBT400213			
INITIALS AND DATE			
DESIGNED BY:	VM 12/21/2017	TOLERANCES: .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACE ROUGHNESS	
DRAWN BY:	VM 01/02/2018		
CHECKED BY:	VM 01/02/2018		
MFG REVIEW BY:	DD 01/02/2018		
APPROVED BY:	ML 01/30/2018	SCALE: NTS	SHEET 1 OF 7
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ML

ITEM #	QTY	PART #	TITLE	PG
-3	1	RBT400213-3	LEFT CLAMP	4
-4	1	RBT400213-4	RIGHT CLAMP	5
-5	1	RBT400213-5	TOP TAB	6
11	4	AN426AD-4-8	C.S HEAD RIVET 1/8" x 1/2" x 100°	-
13	4	AN4-10A	HEX HEAD BOLT 1/4"-28 x 1 1/32"	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
F	TEMPLATE UPDATED, EPOXY CHANGED FOR EPOXY DP460	17-797	17.12.21	VM	ML

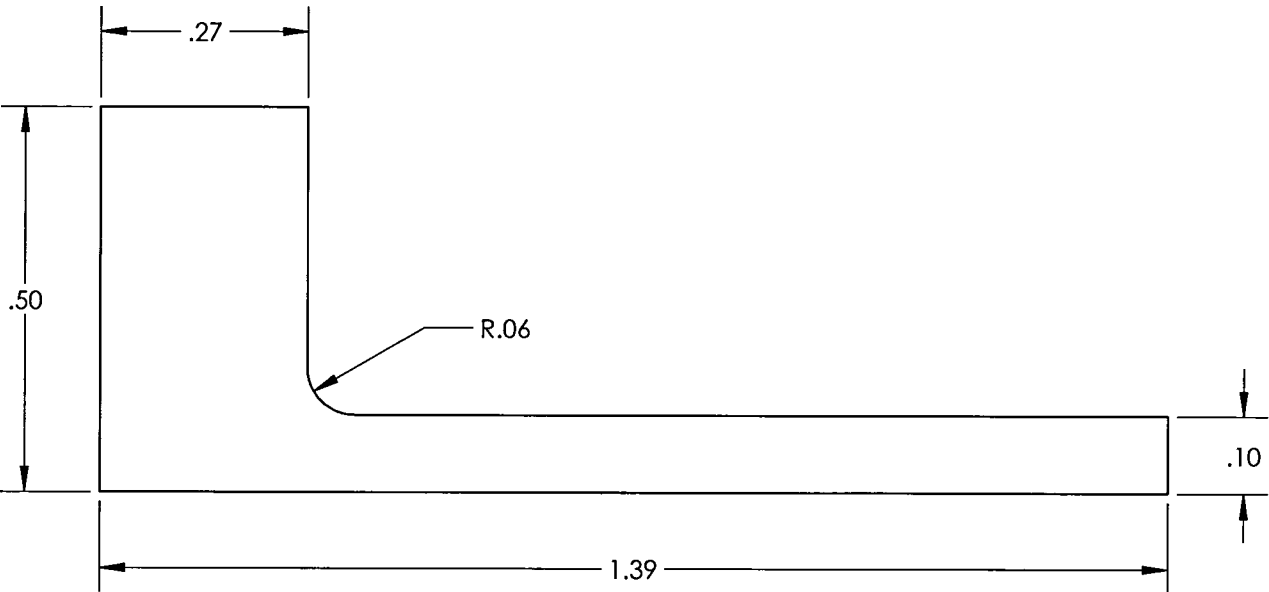
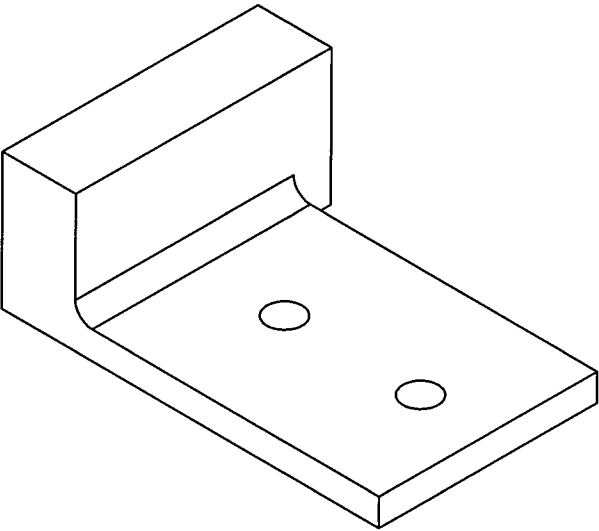
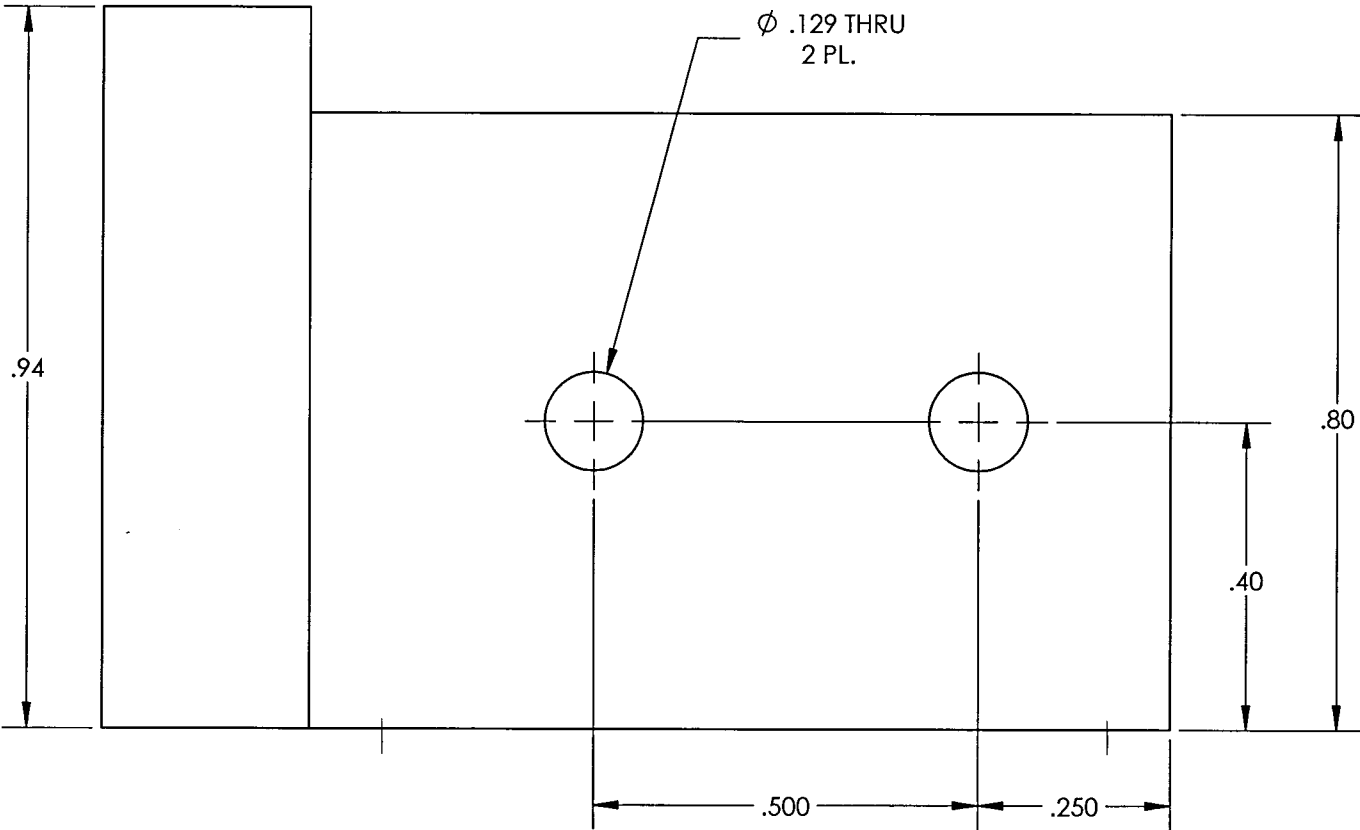


NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) SPEC: N/A
5) BREAK ALL SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) APPLY SCOTCH WELD DP460 EPOXY UNDER BOLT HEAD AND INSTALL BOLT INTO ITEM -5. ALLOW TO CURE PER MANUFACTURER'S INSTRUCTIONS

RBT400213-7 TOP TAB ASSY


DART AEROSPACE Hawkesbury, Ontario, Canada			
TITLE TOP TAB ASSY			
PART NO. RBT400213-7			REV F
TOOL NO. RBT400213		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY:	INITIALS AND DATE	TOLERANCES:	
DRAWN BY:	VM 12/21/2017	.XXX ± .005	FRACTIONS ± 1/8
CHECKED BY:	VM 01/02/2018	.XX ± .01	ANGLES ± .5°
MFG REVIEW BY:	DD 01/02/2018	.X ± .1	SURFACE ROUGHNESS
APPROVED BY:	ML 01/30/2018	SCALE: NTS	SHEET 3 OF 7
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REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
F	TEMPLATE UPDATED, TOLERANCES CHANGED ON DIMENSIONS .937 / .800 / .270 / .500 / .400 TO X.XX	17-797	17.12.21	VM	ML

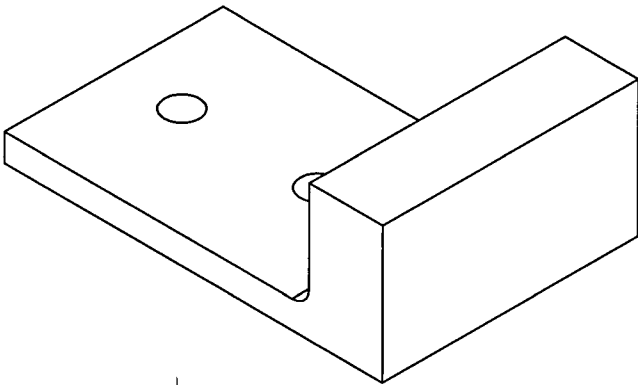
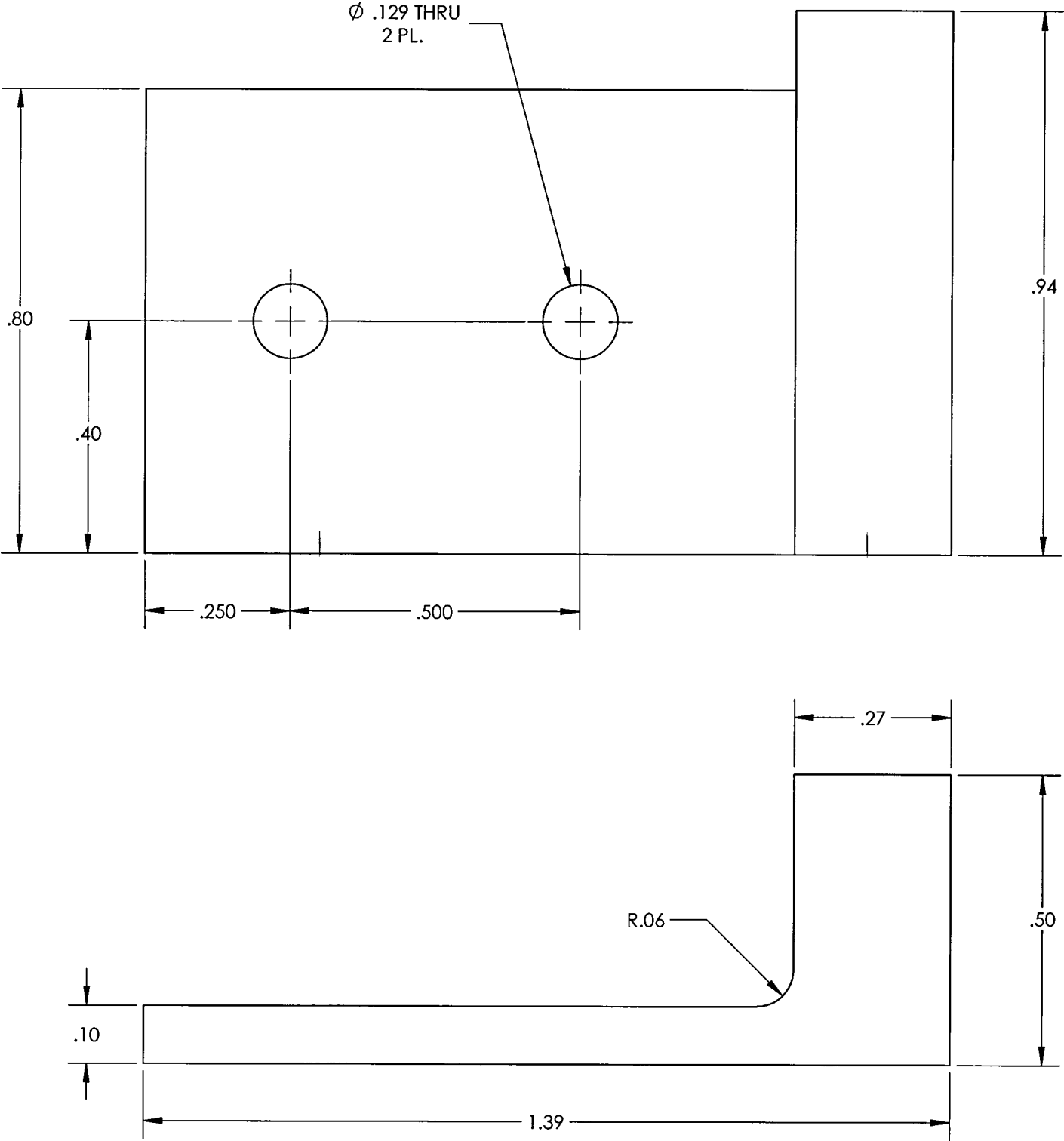


RBT400213-3 LEFT CLAMP

- NOTES:
- 1) MATERIAL: 6061-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: RED ANODIZE
 - 4) SPEC: MIL-A-8625, TYPE II, CLASS 2; WATER SEALANT
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A


 DART AEROSPACE Hawkesbury, Ontario, Canada			
TITLE LEFT CLAMP			
PART NO. RBT400213-3			REV F
TOOL NO. RBT400213		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
INITIALS AND DATE			
DESIGNED BY:	VM 12/21/2017	TOLERANCES:	FRACTIONS $\pm 1/8$
DRAWN BY:	VM 01/02/2018	.XXX $\pm .005$	ANGLES $\pm .5^\circ$
CHECKED BY:	VM 01/02/2018	.XX $\pm .01$	SURFACE
MFG REVIEW BY:	DD 01/02/2018	.X $\pm .1$	ROUGHNESS
APPROVED BY:	ML 01/30/2018	SCALE: NTS	SHEET 4 OF 7
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REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
F	TEMPLATE UPDATED, TOLERANCES CHANGED ON DIMENSIONS .937 / .800 / .270 / .500 / .400 TO X.XX	17-797	17.12.21	VM	ML

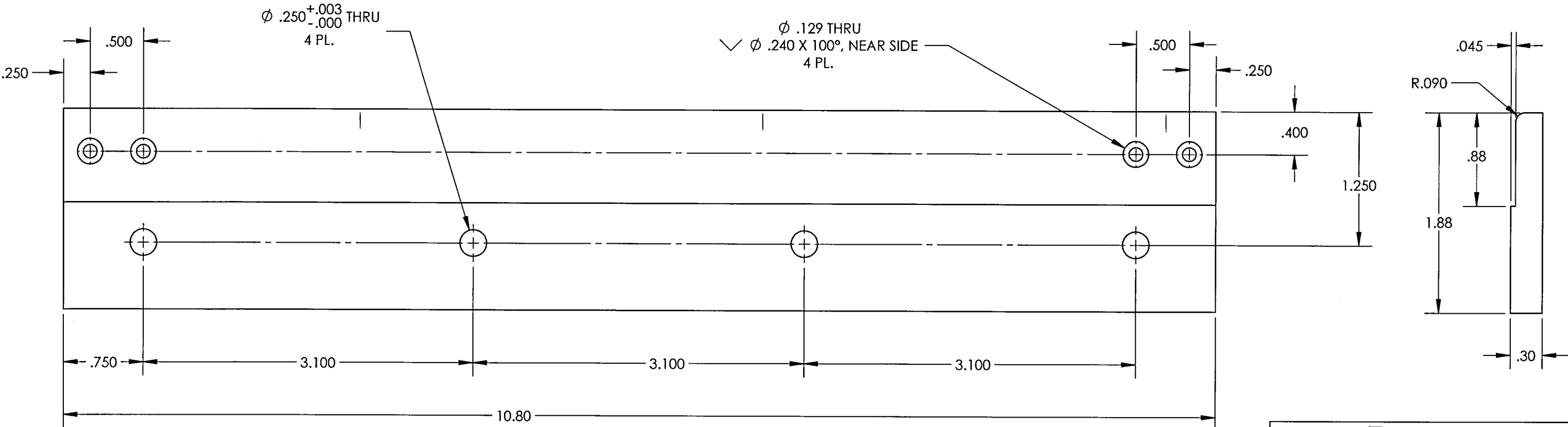
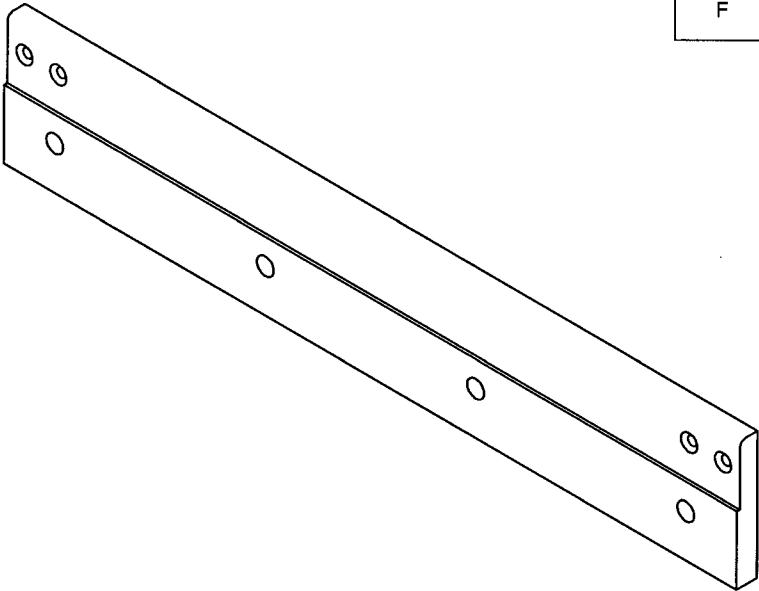


- NOTES:
- 1) MATERIAL: 6061-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: RED ANODIZE
 - 4) SPEC: MIL-A-8625, TYPE II, CLASS 2; WATER SEALANT
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A

RBT400213-4 RIGHT CLAMP

 DART AEROSPACE Hawkesbury, Ontario, Canada			
TITLE RIGHT CLAMP			
PART NO. RBT400213-4			REV F
TOOL NO. RBT400213		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY: VM 12/21/2017		TOLERANCES:	
DRAWN BY: VM 01/02/2018		XXX ± .005	
CHECKED BY: VM 01/02/2018		XX ± .01	
MFG REVIEW BY: DD 01/02/2018		X ± .1	
APPROVED BY: ML 01/30/2018		FRACTIONS ± 1/8	
SCALE: NTS		ANGLES ± .5°	
SHEET 5 OF 7		SURFACE ROUGHNESS	
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REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
F	TOLERANCE ON HOLE .250 CHANGED FOR .250 +.005/-0, TEMPLATE UPDATED	17-797	17.12.21	VM	ML

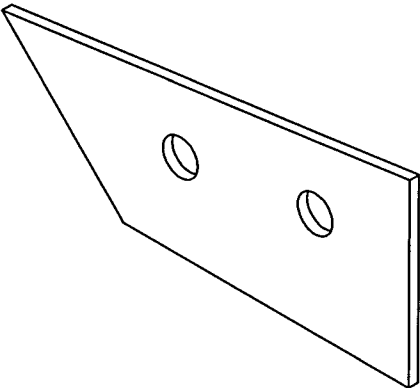
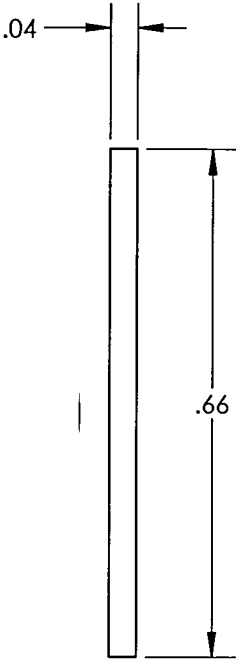
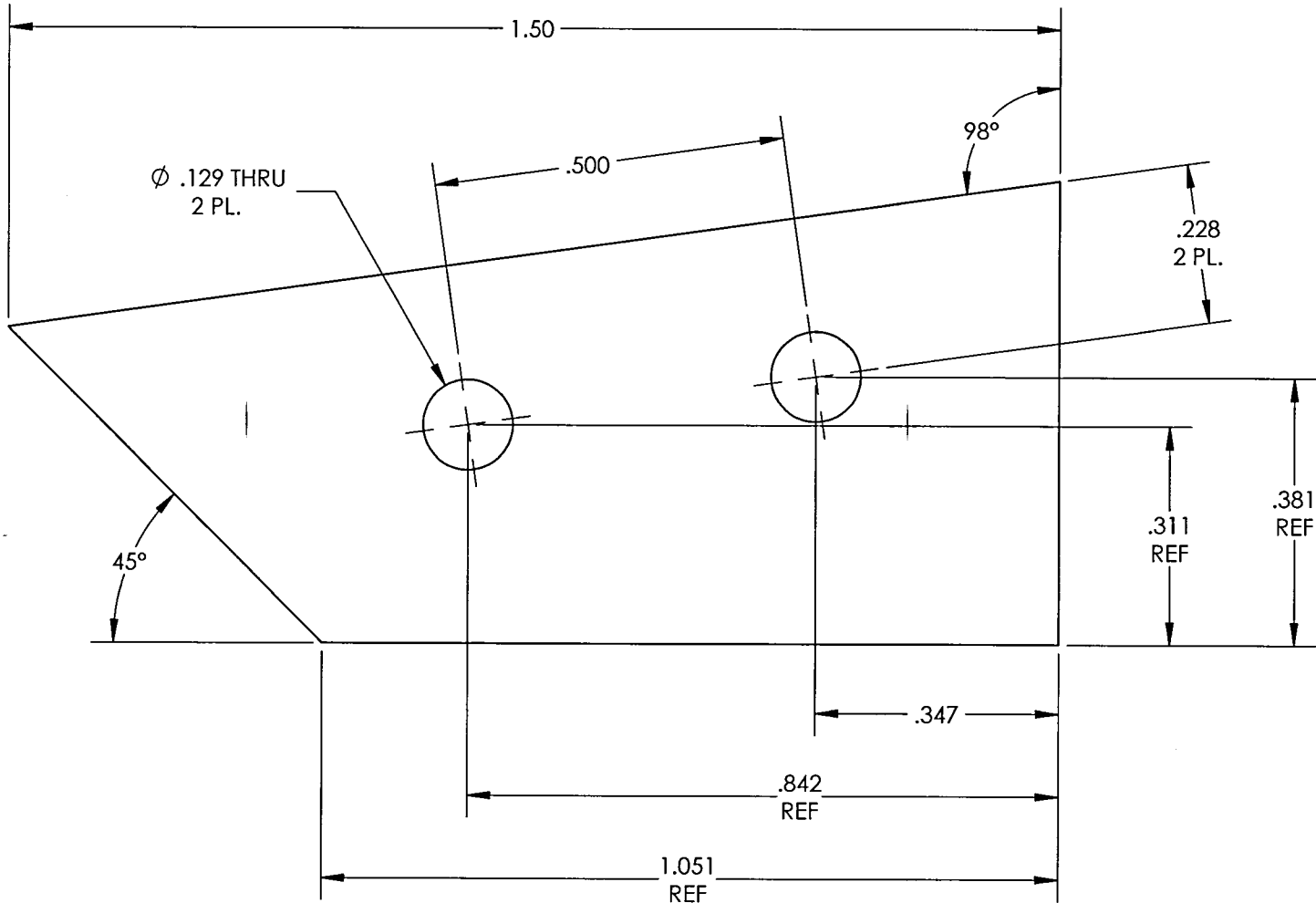


RBT400213-5 TOP TAB

- NOTES:
- 1) MATERIAL: 6061-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: RED ANODIZE
 - 4) SPEC: MIL-A-8625, TYPE II, CLASS 2; WATER SEALANT
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A


DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE TOP TAB	
PART NO. RBT400213-5	REV F
TOOL NO. RBT400213	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY: VM 12/21/2017	TOLERANCES: XXX ± .005 XX ± .01 X ± .1
DRAWN BY: VM 01/02/2018	FRACTIONS ± 1/8 ANGLES ± .5° SURFACE ROUGHNESS
CHECKED BY: VM 01/02/2018	
MFG REVIEW BY: DD 01/02/2018	
APPROVED BY: ML 01/30/2018	SCALE: NTS SHEET 6 OF 7
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REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
F	DRILL HOLE .128 CHANGED FOR STANDARD DRILL SIZE .129	17-797	17.12.21	VM	ML



RBT400213-9 POINTER

- NOTES:
- 1) MATERIAL: AISI 304/316 SS
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A

 DART AEROSPACE			
Hawkesbury, Ontario, Canada			
TITLE POINTER			
PART NO. RBT400213-9			REV F
TOOL NO. RBT400213		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY:	VM 12/21/2017	TOLERANCES:	
DRAWN BY:	VM 01/02/2018	XXX ± .005	
CHECKED BY:	VM 01/02/2018	XX ± .01	
MFG REVIEW BY:	DD 01/02/2018	X ± .1	
APPROVED BY:	ML 01/30/2018	FRACTIONS ± 1/8	
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SCALE: NTS		SHEET 7 OF 7	